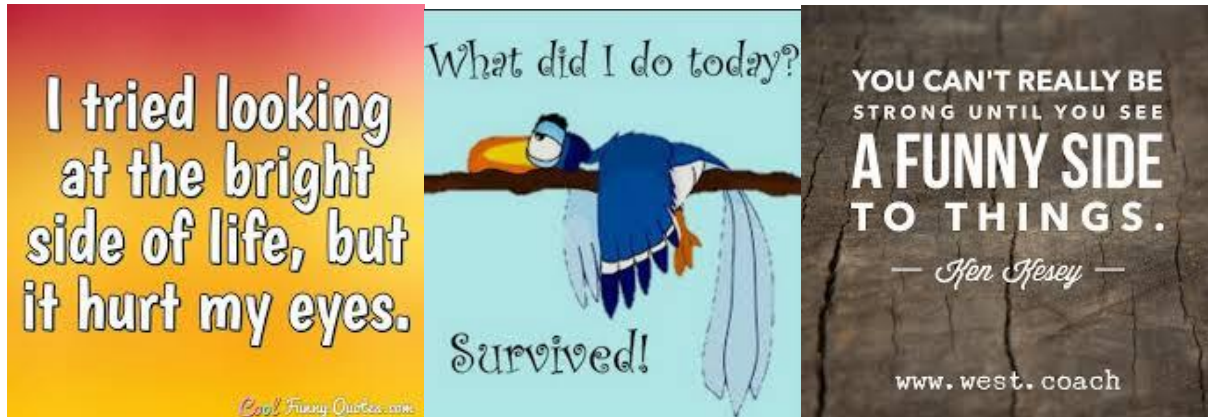


Enjoy Paper making!



Everybody has experiences. I had some unique ones to share with you. Do not tell me you had same? That is cheating. I have decided to enjoy. My experience is not shared verbatim or it may not have been put on paper hundred percent as happened, but it is mostly true.

Story of two gates

You know, each paper machine or machine building has two entrances (at least two, you know why.) They are made as per specifications of the safety department/factory inspectorate/fire. I found a new use for them. The Chief paper maker (CPM) is on rounds. If I am found, there would be a problem; and if not seen, another problem. I must understand that there would be problem any way. I learnt this much later. When he used to enter the east gate, I used to go outside through west side door and so on. This great man invariably enquired about the trainee engineer in shift; and there would be sirens. I would be summoned for a mouthful. As to what I had learnt. Supposing somebody asks you suddenly a very general question like "What did you learn?", what to reply? For heaven's sake, I could not sort out this.

But generations must have used the doorways for this genuine and great purpose, make no mistake.

National integration

This paper making crew is from all over India. It taught me unity of our country. This happens for a particularly important reason. Not patriotism for sure. Did you guess? That is the secret. When the chief paper maker leaves for some reason, his retinue goes with him. That is how we are introduced with people from different states. This time, it is Punjabis and expert operators from UP and Bihar. I found some from Bengal and Orissa too.

Learning a new language (Sign)

It is all din and noise. Mostly from vacuum pumps, dryer gear train, blowers of hoods, nobody can communicate with other. 100 decibels? May be 90. Learn to communicate. Signals for fitter; electrician, instrument mechanic, high basis weight, low basis weight.....Low internal sizing; high refining,If you slightly raise your left hand and show hitting it with a hammer, it is a fitter. If you point out with both hands, it is an electrician. If you roll your fingers of both hands simultaneously and both sides, it is an instrument mechanic.

Khainee paper making

There is great unity among paper making crew. They all exchange khainee. If you do not take khainee, you are looked down. (Ye kahan se aayaa hai?). There is elaborate preparation required for khainee. Expert paper makers sometimes make paper with khainee in left hand and paper with right hand. And it took me lot of time learning paper making with both hands.

They told me: Start eating Khainee and you will become expert in no time. Taking an occasional swig is a different matter. Yes, it took a lifetime learning. You know something? Operators talking to CPM while preparing khainee is considered a merit! It was never looked down. They talk with khainee in the left hand, with right hand covering the mouth lest spittle falls on the great chief paper maker. Very respectful indeed.

Zero-meter, five meter and nine meters

Okay. now zero-meter, five meter and nine meters. I started life at zero meter. I mean on a ground floor machine. Once one of my colleagues stated out of revulsion. What big deal! Even a dog can make paper. Next day a dog went through the bottom felt circuit.

Either they require a man on a five-meter machine, or they found out I was not learning adequately at zero meter. Imagine on the same floor where the CPM has his office!!! Suddenly other trainees become great friends and well-wishers. Discussing paper making seriously. Why? The CPM is walking around. We did not dare to go to zero meter!

How activity begins

Generally, when the chief paper maker is on rounds, there would be lot of brouhaha. Suddenly there would be activity. People start working on jobs which were not normally undertaken or for that matter, necessary! They suddenly assume importance. They become very priority jobs. This much I learnt through his profoundly serious nod. What a show!

An incident or series of incidents pushed me to go to zero meter. When on duty at press part as part of our training programme, as the CPM is close by, the operator appears

and murmurs something in his ears. The CPM is all ears. Siren followed by signal for fitter; the fitter arrives and dispatched to the zero meter. This happened a few times in different shifts. I was curious.

I followed the fitter secretly. He went to a non-return –valve at the bottom of UHLE box drop leg and came back. All is well. I later learnt that because of complaint from the paper machine operator, fitter was summoned and asked to repair the non-return-valve. During a shut, I went to the NRV. It is a simple flap. Nothing is required. What is all this about? No water is coming out of the NRV. It cannot come, since the physical location of UHLE box is such, the height of the drop leg is inadequate to support the vacuum level. When I explained,

Changing angle of couch suction box of wire.

This is another routine when high substance paper is taken up. High vacuum in suction couch gave shadow marking in paper. So, fitter comes, and chief paper maker surveys. Adjusts the vacuum level, by rotating the box and leaking. They never arranged a vacuum breaker in pipeline.

We established later that shadow is from suction press, not suction couch!

Refining

Yahan be refining hotha hai! This I enjoyed hearing. Because, I heard it as a student of chemical engineering. I was anxious to see the distillation column and all. I asked several people. I was taken to a beater first and a stock refiner next. I almost fainted.

How to know the quality of heat??

(I mean the temperature of dryer cylinder surface). Present day paper makers simply test with instrumentation. A simple job. (They have it extremely easy yaar). We had to feel it with the palm and tell!

Pan cakes and the art of paper making

Did you not see pan cakes being made in your kitchen? That is drying, told my operator. Are bhai ye pan cake kya hai, ye drying kyahai? Batata hoon, told me the operator, putting khainee in his mouth.

Salah (this is a common word in paper making, though not in technology). Paper making itna aasaanit hodi hai. To generations prior to mine, paper making WAS an art. To our generation, science showed up. To our next generation, a mixture of art, science, and engineering, and currently it is all electronics& instrumentation. Bhai ye pan cake kyahai? I am stumped again. When tavva is hot, pan cake sticks to the pan. You cannot take out intact! It peels off into pieces. So is paper! So keep it slightly warm in the beginning and heat it up slowly (itna tho jaanna chahiye)!

Only two common words pan India

Paper mills are spread across the country. Can you guess which are 2 most common word that are spoken through out various states of India irrespective of its mother tongue. You guessed it right ---- It is HARIYA & HABIS. This is spoken by crane operator while lowering (Hariya) or lifting (Habis) an object. Such unity in diversity keeps Indian paper mills going.



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